



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D205-634-041
Job Sheet 198772



Part No: D205-634-041

Job Qty: 1 pcs

Part Name: Replacement Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/6/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 8/30/19

Type: Stock

Description:

Note: DWG D2580 REV H SHEETS 1,2,3,8 IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD IPP Rev. O 06.02.28 Added paperwork EC IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q 10.12.01 as per chg003 DD ver:EC IPP REV:R 12.01.23 AS PER ECN11-684 VERF:EC IPP REV:S 17.12.08 REMOVE GASKET AS PER INTUITIVE INFO DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - Bend - 1	1 pcs		8/30/19	0.00	0.65	Skidtubes - Bend		MGA
120	Skidtubes - 2 - B4B	1 pcs		8/30/19	0.00	2.89	Skidtubes - 1 - B4B		
							Skidtubes - 2 - B4B		
							Skidtubes - 3 - B4B		MGA
							Skidtubes - 4 - B4B		
							Skidtubes - 5 - B4B		
							Skidtubes - 6 - B4B		
							Skidtubes - 7 - B4B		
130	QC 5	1 pcs		8/30/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		BE
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		



Container No: S210761



Part: D205-634-041

Job No: 198772

Serial No/Batch: S210761

Revision: H

Inspector:

Exp Date:

Instructions: TC STC SH96-88 Issue 3, FAA STC SR005631

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

140 Skidtubes - 3 - B4B	1 pcs	8/30/19	0.00 3.00	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
150 QC 10	1 pcs	8/30/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	DAS
				QC 10 - 43	24
				QC 10 - 50	9-89
				QC 10 - 58	
				QC 10 - 9	
160 QC 5	1 pcs	8/30/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	DAS
				QC 5 - 9	SEP 10 2019 68
				QC 5 - 50	9-89
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
170 Handfinish - 1-1 Chemical-B4B	1 pcs	8/30/19	0.00 1.31	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	SEP 13 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 -	

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				B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
180 Powdercoat - 1 White GI(A)- B4B	1 pcs	8/30/19	0.00 0.34	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
START: 12:35 O.V.T. 30° FINISH: 1:05.				BL 19-9-20	
190 QC 3	1 pcs	8/30/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	42 19-9-20
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
QC 3 - 24					
QC 3 - 61					
QC 3 - 81					
200 Handfinish - 4-1-Assembly- B4B	1 pcs	8/30/19	0.00 1.00	Handfinish - 4 - 1 - B4B	40 19-9-20
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
Handfinish - 4 - 9 - B4B					
210 QC 5	1 pcs	8/30/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				Plex 8/6/19 11:49 AM Dart.lajeunesse.marie	

DAS
15
9-89

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					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	DAS SEP 2 5 2019 40 9-89
					QC 5 - 61	
					QC 5 - 81	
220	Packaging 3-1 - Stock - B4B	1 pcs	8/30/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	DAS 21 9-89
					Packaging 3 - 36 - B4B	SEP 2 6 2019
225	DC - 1 - B4B	1 pcs	8/30/19	0.00 0.00	DC - 1 - B4B	
					DC - 2 - B4B	
230	QC 21 - FG	1 pcs	8/30/19	0.00 0.00	QC 21 - FG - 21	DAS 21 9-89
					QC 21 - FG - 70	SEP 2 6 2019
					QC 21 - FG - 53	

Part Op 110 - Skidtubes - 1-Bend as per program D2580.C on CNC Bender and Folio 16 2-Cut tubes as per Dwg. D2580 3- scribe
 Descriptions: batch# in aft end of tube
 120 - Skidtubes - 1- Deburr ends and remove bending marks 2- Prepare tube for welding as per QSI 004
 130 - QC5- Inspect part completeness to step on W/O
 140 - Skidtubes 1-Weld step D2576 as per Dwg. D2580 and QSI 004 2-Grind welds on step as per Dwg D2580 3- Insert
 D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube

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expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension. 4-Drill holes for wearplates using DT 8217 & DT8937, 7.40" from most fwd saddle holes (ref only) Open holes to 19/64", adjust stopper not to hit web. Deburr 5-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr 6-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

150 - QC10- Inspect visual per QSI004- ground welds

160 - QC5- Inspect part completeness to step on W/O

170 - Chemical Conversion Coat per QSI005 4.1 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

180 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

190 - QC3- Inspect Part Finish

200 - Assemble as per dwg - 1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 520662 Sikaflex expire date: 06-7-22 Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580 3-Inspect for foreign object per QSI 024 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291 520662 Sikaflex expire date: 06-7-22 5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: 5209362

210 - QC5- Inspect part completeness to step on W/O - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220 - Identify and pack for shipping as per PPPD205-634-041 Location: _____ PPP Rev: _____

225 - Document Control - Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG006

230 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2580-1	205 Bent Tube	1 pcs (1 ea)	110-Skidtubes - Bend - 1	5209381
D2576-3	Step (Machining Detail)	1 pcs (1 ea)	140-Skidtubes - 3 - B4B	5177095
D4202-1	Spacer	20 pcs (20 ea)	140-Skidtubes - 3 - B4B	5154382
ALS7-1032-130	Rivnut	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	5190021
AN3-5A	Bolt	2 Ea (2 ea)	200-Handfinish - 4-1-Assembly-B4B	5149159
AN3C4A	Bolt	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	5209067
D2594-1	Plug	16 pcs (16 ea)	200-Handfinish - 4-1-Assembly-B4B	5196149
D2594-3	O-Ring	16 pcs (16 ea)	200-Handfinish - 4-1-Assembly-B4B	5173297
D2855	Cap	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5126188
D3564-11	Wearplate Aft	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5201761
D3564-13	Wearpad Fwd	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5196227
D3564-5	Wearplate Center	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5201529
D3564-9	Wearplate Fwd	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5201653
NAS1149C0332R	Washer (AN960C10L)	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	5193136
NAS1149D0332J	Washer	2 Ea (2 ea)	200-Handfinish - 4-1-Assembly-B4B	5178370

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - Bend - 1	D2580-1	1	4	0
140-Skidtubes - 3 - B4B	D2576-3	1	78	0
	D4202-1	20	861	0
200-Handfinish - 4-1-Assembly-B4B	ALS7-1032-130	50	1,256	0
	AN3-5A	2	84	0
	AN3C4A	50	1,293	0
	D2594-1	16	170	0
	D2594-3	16	195	0
	D2855	1	93	0
	D3564-11	1	27	0
	D3564-13	1	16	0
	D3564-5	1	16	0
	D3564-9	1	18	0
	NAS1149C0332R	50	3,456	0
	NAS1149D0332J	2	2,549	0

Part Specifications

Specifications could not be found.

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ITEM	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
1	X	-041	-040	D2590-041	SKIDTUBE ASSEMBLY
2		X		D2590-045	SKIDTUBE ASSEMBLY
3			X	D2590-047	SKIDTUBE ASSEMBLY
4			X	D2590-049	SKIDTUBE ASSEMBLY
20	1	1	1	D2590-1-100	EXTRUSION
21			18	D2570	BUSHING
22	1	1	1	D2570-3	STEP
23		4		D2579	SPACER
24	18	18	8	D2584-1	PLUG
25	18	18	8	D2584-3	O-RING
26	1	1	1	D2588	208 WEB
27	1	1	1	D2588	AFT CAP
28	1	1		D2584-5	WEARSHOE
29	1	1		D2584-9	WEARSHOE
30	1	1		D2584-11	WEARSHOE
31	1	1		D2584-13	WEARSHOE
32	20	20	24	D4005-1	SPACER
33			1	D4005-041	WEARPLATE ASSEMBLY
34			1	D4005-045	WEARPLATE ASSEMBLY
35			1	D4001-4	END WEARPLATE
36			1	D4001-3	AFT WEARPLATE
50	50	50		AL57-1032-130 or AK57-1032-130 or AK58-1032-130 or AK59-1032-130	INSERT
61	60	60		AK58-04	BOLT
62	2	2	2	AK58-04	BOLT
63			8	AK58-04	BOLT
64	60	60		NA5114800332R	WASHER (AN800C10L)
65	2	2	2	NA5114800332J	WASHER (AN800C10L)
66			8	MS21042-4	NUT (OR MS21042-4)

GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART Q81 005 4.1 PRIOR TO INSERTING D2590 WEB POWDER COAT (J4114047040) GLOBS WHITE (REF 4.3.5.1) PER DART Q81 005 4.3 BLACK ANTI-SEED PAINT AS INDICATED PER DART Q81 005 4.4.
- 3) TOLERANCES ARE PER DART Q81 010 UNLESS OTHERWISE NOTED.
- 4) LIMITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2590-041 = 55.7 lbs
D2590-045 = 33.7 lbs
D2590-047 = 46.1 lbs
D2590-049 = 32.0 lbs
- 8) WELDING PER DART Q81 004.
- 9) INSERT D2590 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SLOPEX-541 ADHESIVE PER DART Q81 016 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DTEK17 & DTEK57 ONLY FOR D2590-041-049 TO LOCATE AND DRILL 20.307 HOLES FOR WEARSHOE INSERTS. INSTALL AL57-1032-130 PER SECTIONS B-B AND F-F (80 PLACES) AFTER FINISH. INSTALL AN58-04 BOLTS AND NA5114800332R WASHERS WITH SKALEX 3411-291.
- 12) INSERT D2590-1 PLUG CW D2590-3 O-RING IN HOLES MARKED "P" (BOTH SIDES OF TUBE) AFTER FINISH (10 PLACES FOR D2590-041-045 AND 8 PLACES FOR D2590-047-049)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2590 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 198772 MWS
19-08-06

RELEASED
2017 JUL 05
5007-519

REV.	DESCRIPTION	DS	SAD	DATE
H	SHEET: PL DELETE D2590-1-04-13 GASKETS, WEIGHTS UPDATED ACCORDING TO SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	SAD		17.06.09
G	ADDED -046 -047 WEIGHT UPDATED PER D81 9006	AS		14.04.08
F	INCORPORATE D80 D2590-E-1 PER PARTS-216	DC		13.08.20
E	ADD D2590-047 (2N CA-7) AND D2590-7 (2N ES-01) INCLUDED D80 D2590-0-1; REFORMAT DRAWING TO CURRENT STANDARD; DTEK17 & DTEK57 WAS T02577-208 (2N CA-1)	RF		11.06.21
D	CHANGE TO 88 WEARPLATES AND GASKETS, INCLUDE D80 8124/8183	PH		07.04.05
C	REDRAWN, INCLUDED D80 8094/8097	CP		04.08.28
B	AS MANUFACTURED	DS		05.12.02
A	NEW ISSUE	DS		04.06.16
REV.	DESCRIPTION	DS	BY	DATE
DESIGN				
DRAWN				
CHECKED				
INFL. APPR.				
APPROVED				
DE APPR.				
DATE	17.06.09			

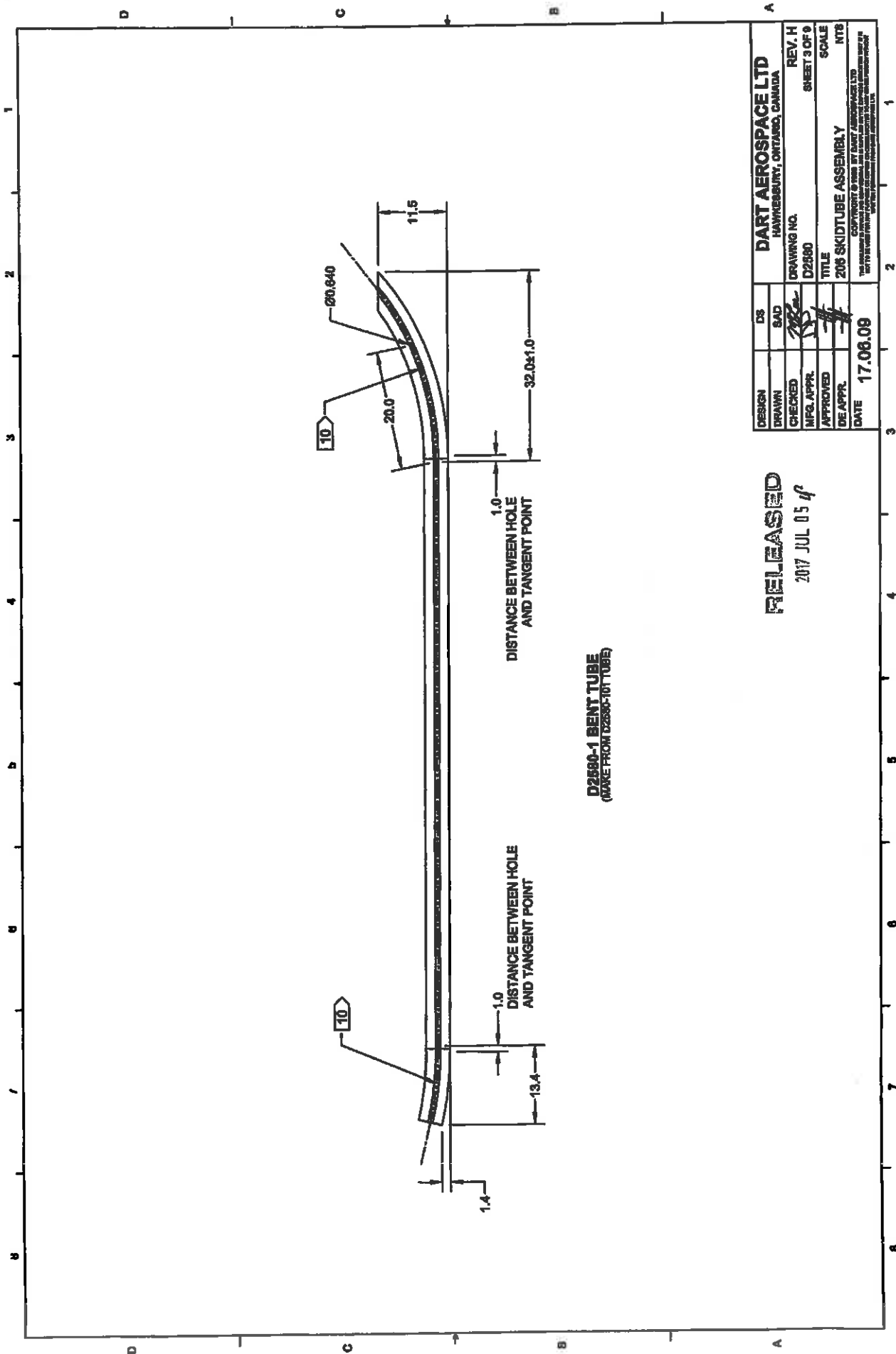
DART AEROSPACE LTD
HARRISBURG, ONTARIO, CANADA

REV. H
DRAWING NO.
D2590

SHEET 1 OF 8
SCALE
NTS

TITLE
205 SKIDTUBE ASSEMBLY

COMPONENT Q TUBE BY DART AEROSPACE LTD
THE TUBE AND END VIEW SHOWN ARE FOR INFORMATION ONLY
DO NOT USE FOR MANUFACTURE

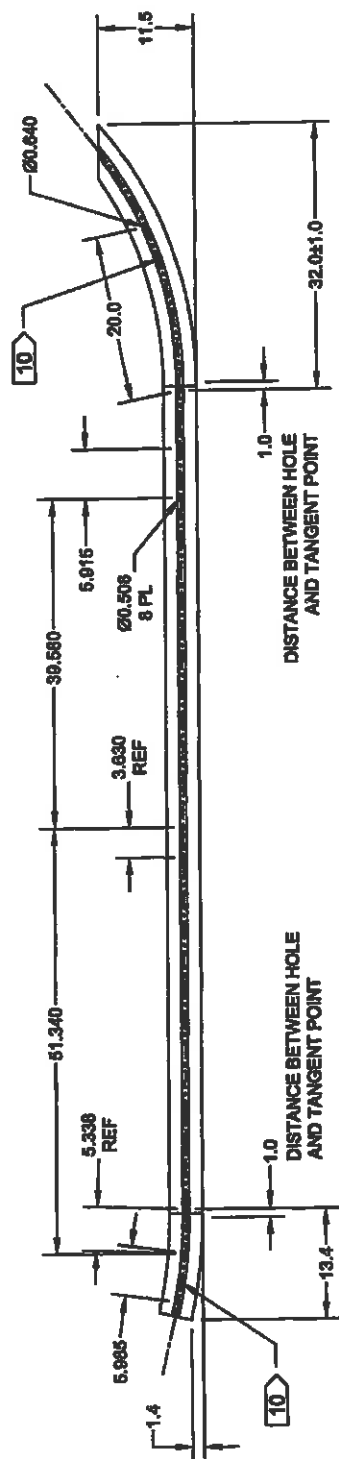


D2590-1 BENT TUBE
(NAME FROM D2590-101 TUBE)

RELEASED
2017 JUL 05

DESIGN	DS	DART AEROSPACE LTD
DRAWN	SAD	HAWTHORNS, ONTARIO, CANADA
CHECKED	7/2/2	DRAWING NO.
INFL. APPR.	1/2/2	D2590
APPROVED	1/2/2	REV. H
DATE	17.06.09	SHEET 3 OF 9
		SCALE
		2006 SKIDTUBE ASSEMBLY
		NTS
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1 2 3 4 5 6 7 8

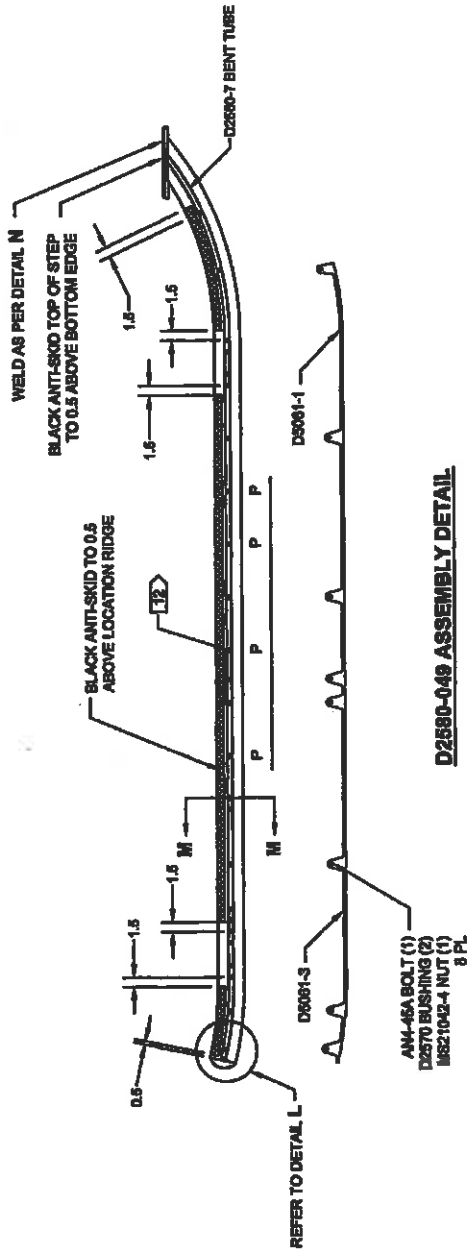


D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

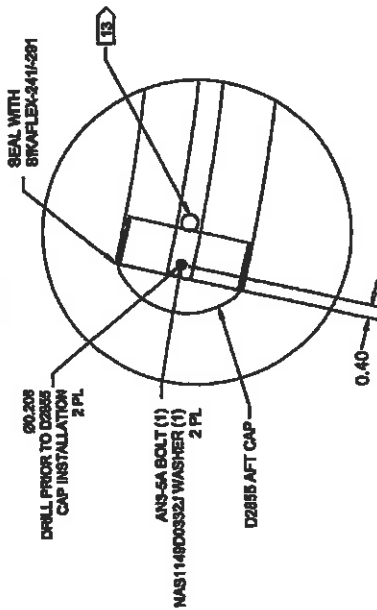
RELEASED
2017 JUL 05

DESIGN	DS	DART AEROSPACE LTD
DRAWN	SAD	HAWKSBURY, ONTARIO, CANADA
CHECKED	7/8	DRAWING NO.
MFG. APPR.	7/8	D2580
APPROVED	7/8	TITLE
DE APPR.	7/8	205 SKIDTUBE ASSEMBLY
DATE	17.06.09	NTS

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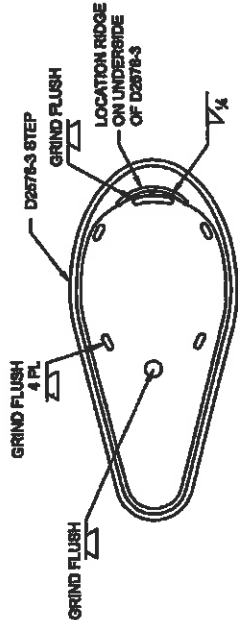
DETAIL L
SCALE 5X



SECTION M-M
SCALE 5X

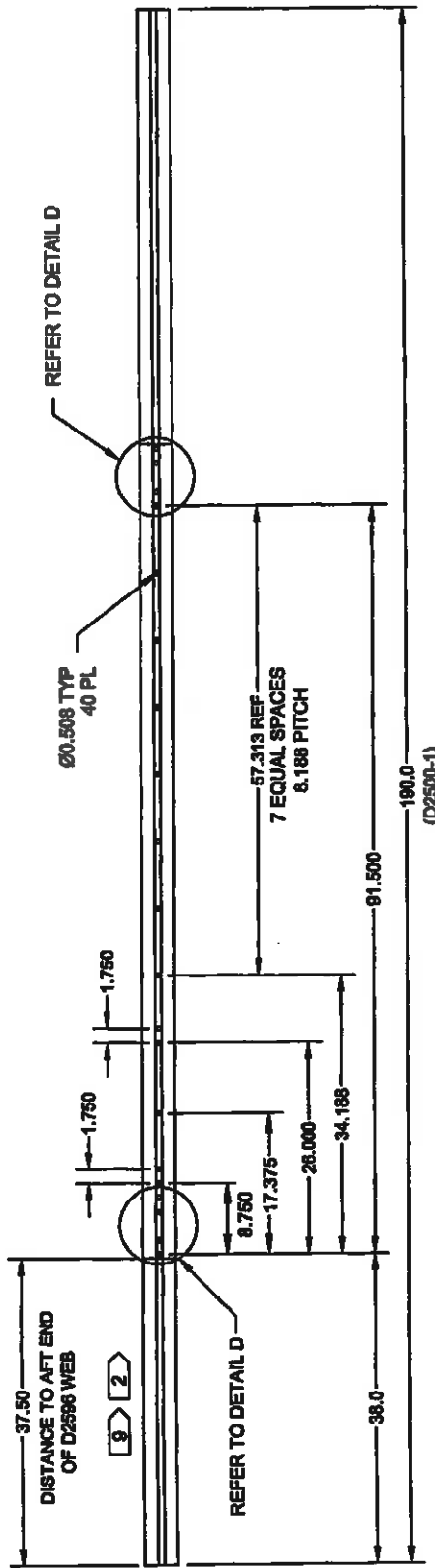


DETAIL N
SCALE 5X

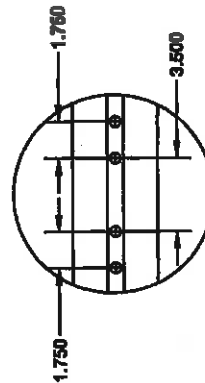


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 60.508 HOLES ONLY:
1. INSERT D002-1 SPACER (24 PLACES)
2. SWAGE TO 90.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

RELEASED
2017 JUL 05



D2590-101 TUBE



DETAIL D
SCALE 5X

RELEASED
2017 JUL 05

DESIGN	DS	DART AEROSPACE LTD
DRAWN	SAD	HAWTHESBURY, ONTARIO, CANADA
CHECKED	REV. H	DRAWING NO. D2880
MFG. APPR.	SHEET 9 OF 9	
APPROVED	TITLE	208 SKIDTUBE ASSEMBLY
DE APPR.	SCALE	NTS
DATE	17.06.09	

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____ Part No. _____		DISPOSITION				DEPARTMENT/PROCESS				MRB (QSI042)																			
Date: _____		Sequence #: _____		QTY Affected: _____		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																			
Description Work Order Deviation						Disposition																							
Root Cause						FAULT CATEGORY																							
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐						Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____						Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐						Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐						Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					
						Completed By						Lead hand / Supervisor						QC / QA Coordinator											